

Work Order ID 60011

Tuesday, June 22, 2010 3:22:11 PM



Page 1

Item ID: D4044-043

Accept



Setup Start



Revision ID:

Item Name: Center Rib Assembly

Stop



Start Date: 6/22/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/30/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: *M*
QC:Date: *10/06/22* Tooling: _____
Date: _____ SPC (Y/N): _____Date: _____
Date: _____Run Start
StopSequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D4044	A

100

0.00



Large Fab

Memo

0.00

1- Cut tube 60" and remove identification markings
 2- Bend tube with manuel pipe bender as per template DT9579 (Make first line at 15.00")
 3- Drill and chamfer holes in D4044-3 as per dwg D4044
 4- Trim access tube material to finish size as per dwg D4044
 5- weld bushing as per dwg D4044
 A/R S.S. rod Batch: *M108775*
 6- grind welds flush

*Ph →**② ID 10.06.23*

110

0.00



QC

QC5- Inspect part completeness to step on W/O

0.00

*S10/06/23**(X2)*

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4044-013 PAR #: _____ Fault Category: Change Pnt. NCR: Yes No DQA: / Date: 10-06-23
 Resolution: _____ Disposition: _____ QA: N/C Closed: / Date: 10/06/24

NCR: 60011		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10-06-23	106	Scrap First Part because line on jig wasn't exact, & line was off by 1/8 on Second bend	<u>QSCW</u>	<ul style="list-style-type: none"> - Scrap & destroy - replace QTY 1 - remove scribble line on jig & re-align. by 1/8 the bend tangent line. 	SAD 10-06-23	<u>QSCW</u>	<u>10-06-23</u>	<u>10-06-23</u>
		R.C. tooling.						

NOTE: Date & initial all entries

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Page 2

Item ID: D4044-043

Revision ID:

Item Name: Center Rib Assembly

Start Date: 6/22/2010 Start Qty: 2.00

Required Date: 7/30/2010 Req'd Qty: 2.00

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC10- Inspect visual per QSI004- ground welds	0.00	8 w/06/23						
130 Packaging Packaging	Identify as per dwg & Stock Location: <u>basket</u>	0.00							

130 Packaging Packaging	Identify as per dwg & Stock Location: <u>basket</u>	0.00							
	Memo	0.00							

140 QC Quality Control	QC21- Final Inspection - Work Order Release	0.00							
	Memo	0.00							

10/06/23
R/ 10-6-24
2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, June 22, 2010 3:22:16 PM

Page 1

Work Order ID: 60011



Parent Item: D4044-043



Parent Item Name: Center Rib Assembly

Start Date: 6/22/2010

Required Date: 7/30/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: new issue DD 10/01/05 verified by:EC IPP Rev:B as per dwg
revA DD 10.02.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3759-1 		Manufactured		No		100	Each	96.0000	3	6		PD 10.06.23	

Bushing

Location	Loc Qty	Loc Code
WA	96	
54072	9	
59419	45	(6)
59644	42	

M304TS0.750W.049



Purchased

No

304 SQ Tube .75x.75x.049W

Location	Loc Qty	Loc Code
MAT	146.7944919	
113763	0	
114323	28.3020789	
114677	14.34201	
114835	104.150403	10.52632
MAT017	3.68448E-05	
114298	3.6845E-05	
WA	300	
114992	300	

SAD 10-06-23

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NOTE: Date & initial all entries

8

7

6

5

3

2

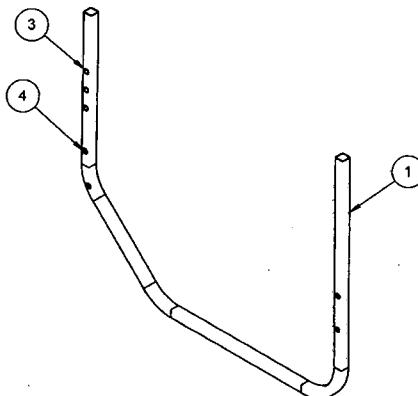
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SHOP COPY

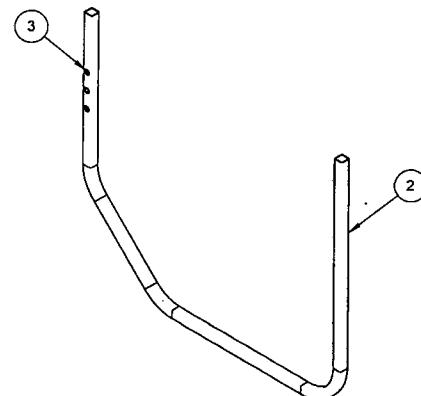
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *602011*

B10-6-22

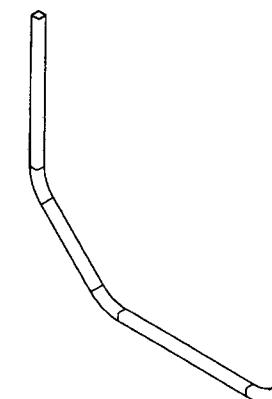
ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4044-041	FWD RIB ASSY
		X	D4044-043	CENTER RIB ASSY
1	1		D4044-1	FWD RIB
2		1	D4044-3	CENTER RIB
3	3	3	D3759-1	BUSHING
4	4		D4021-9	BUSHING



D4044-041 FWD RIB ASSEMBLY



D4044-043 CENTER RIB ASSEMBLY



D4044-5 AFT RIB

RELEASED
2010-02-16
W

A	NEW ISSUE	RF	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>Q</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>AS</i>	D4044	SHEET 1 OF 5
APPROVED	<i>AS</i>	TITLE	SCALE
DE APPR.	<i>AS</i>	RIB ASSEMBLY	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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2

1

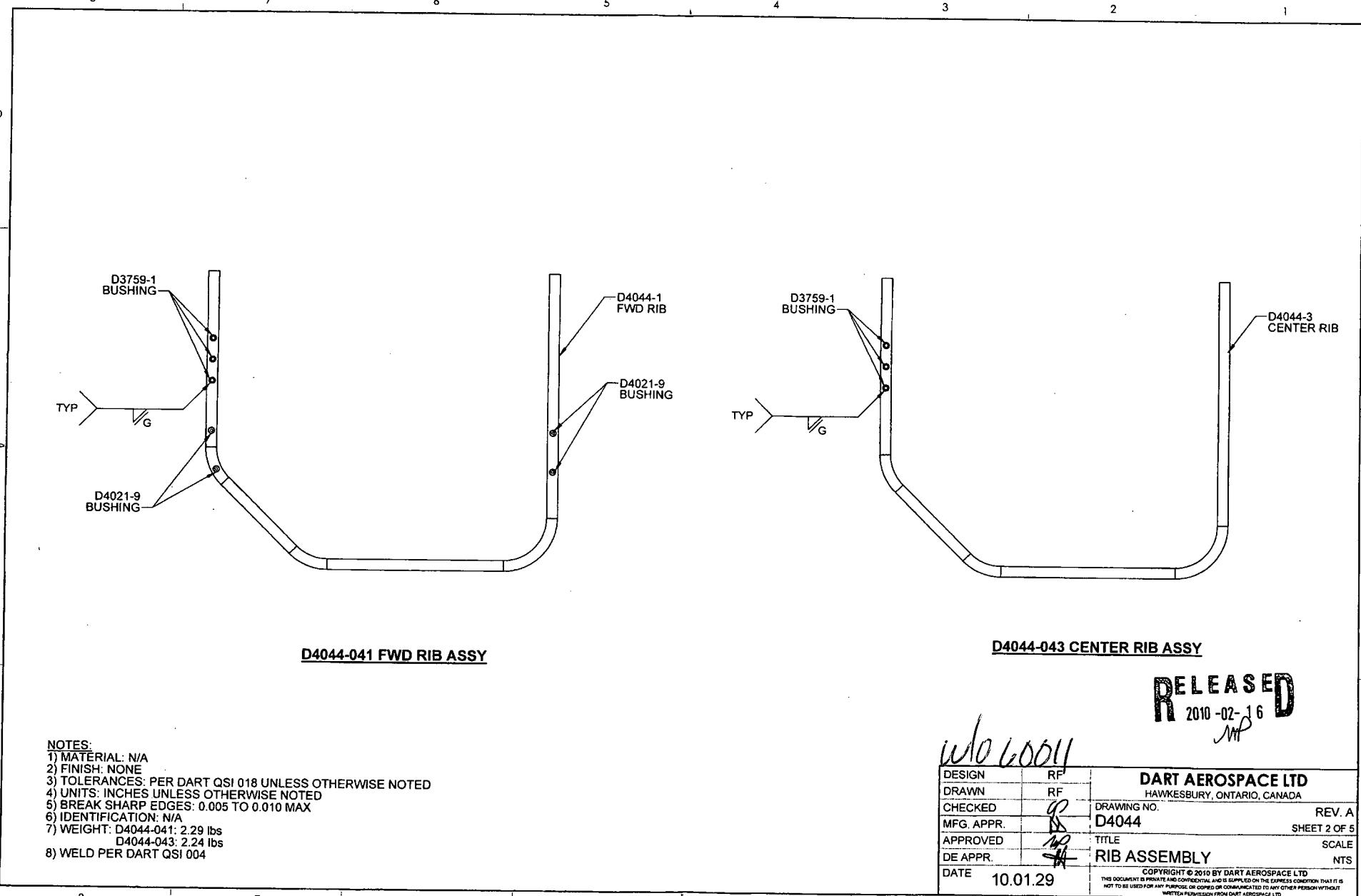
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NOTE: Date & initial all entries



W060011

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>Q</i>	REV. A
MFG. APPR.	<i>N</i>	D4044
APPROVED	<i>MP</i>	SHEET 2 OF 5
DE APPR.	<i>SH</i>	TITLE
DATE	10.01.29	SCALE
		NTS

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2010-02-16
MP

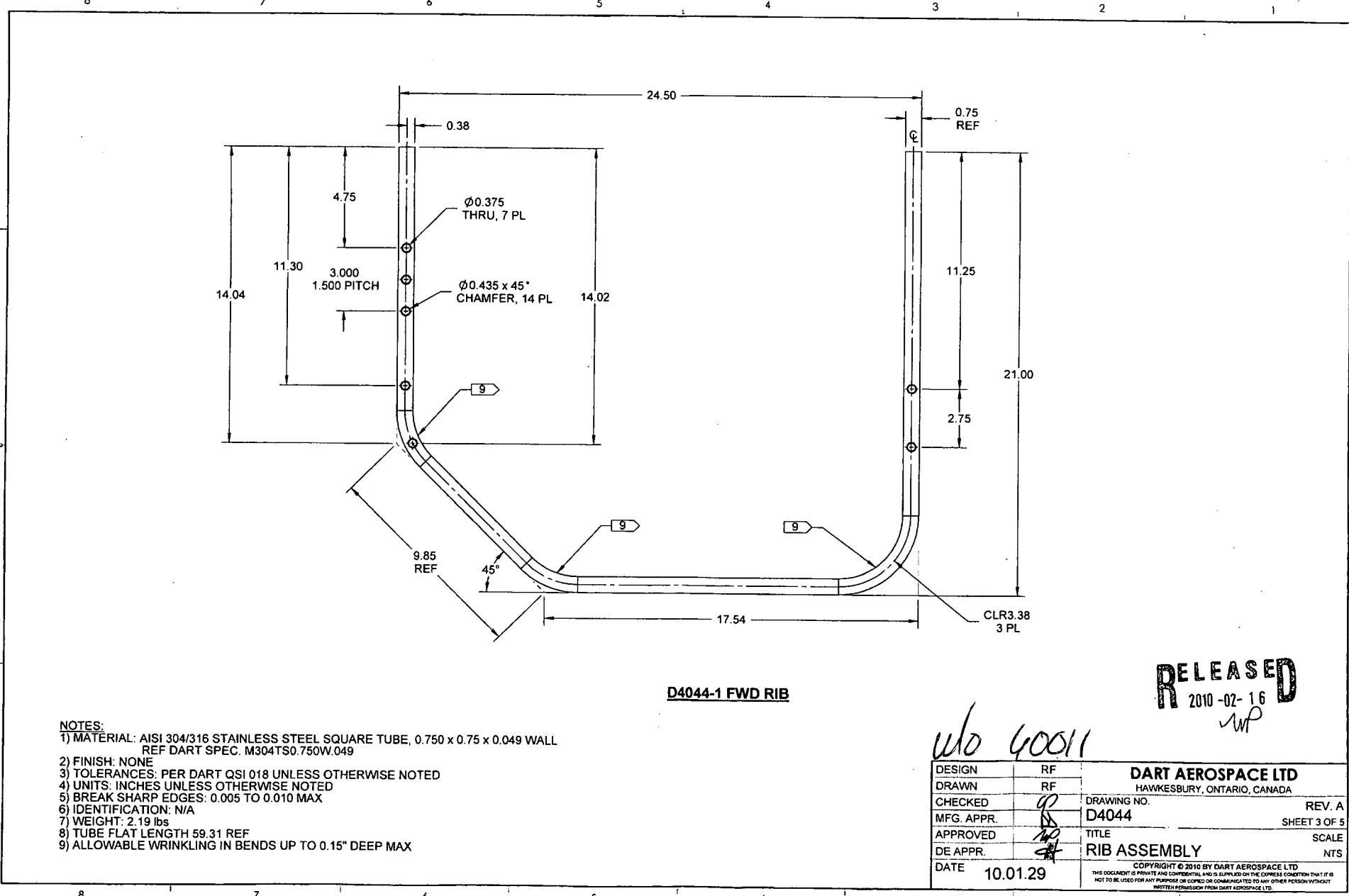
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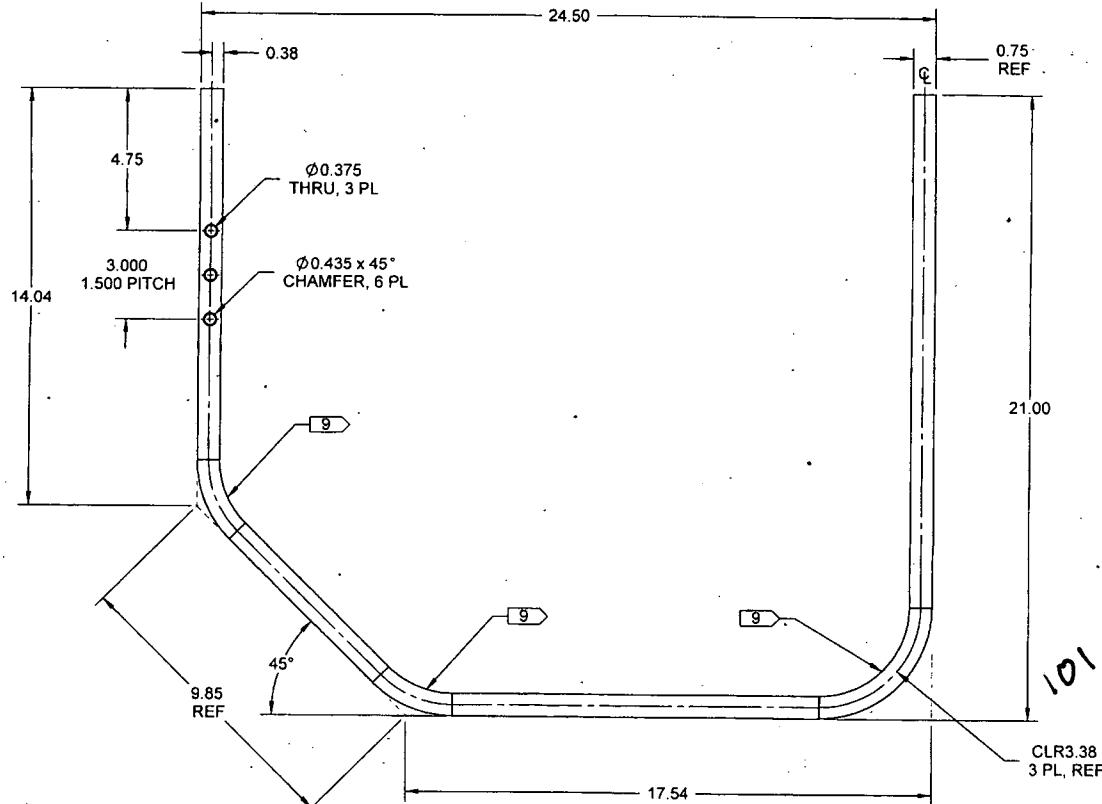
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D4044-3 CENTER RIB

RELEASED
2010-02-16
MP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.750 x 0.75 x 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.20 lbs
- 8) TUBE FLAT LENGTH 59.31 REF
- 9) ALLOWABLE WRINKLING IN BENDS UP TO 0.15" DEEP MAX

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	99	REV. A
MFG. APPR.	15	DRAWING NO.
APPROVED	10	D4044
DE APPR.	11	SHEET 4 OF 5
DATE 10.01.29		TITLE RIB ASSEMBLY
SCALE NTS		

w/o 60011

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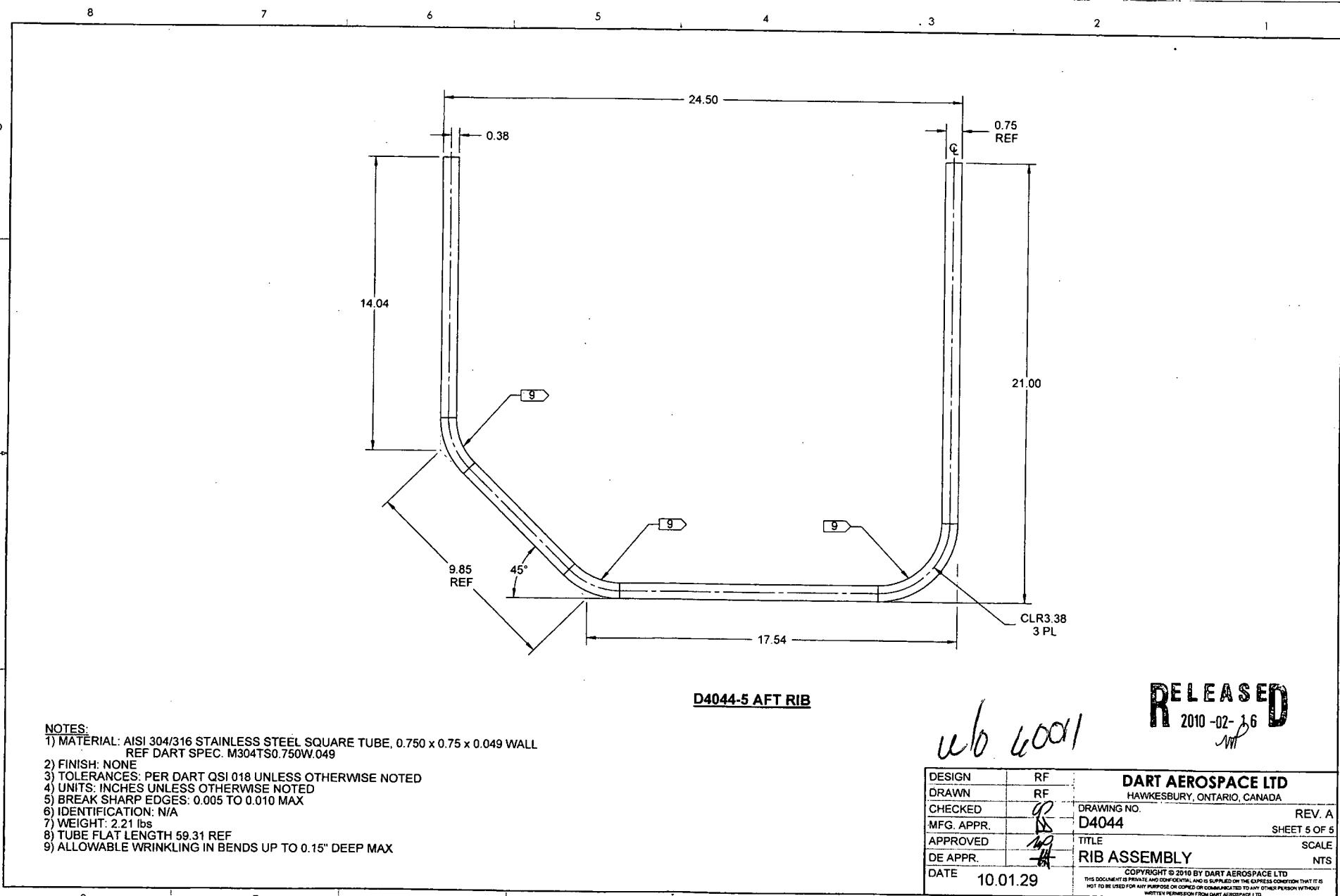
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						✓ RKA		

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